

Work Order ID 124827

September-24-14 8:44:23 AM

slip Sept. 30

\*124827\*

Page 1

Item ID: D4353-041

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bearpaw Assembly

Start Date: 9/24/14

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 9/30/14

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4353

B

120

0.00

\*120\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D4353-1 File

3

14/09/24

130

0.00

\*130\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per FolioFB050 and Dwg

FOLIO REV: AA

DWG REV: B

3-Deburr

14/09/26  
14/09/27

3

September-24-14 8:44:23 AM

**\*124827\***

Page 2

<b>Item ID:</b>	D4353-041	<b>Accept</b>	<b>*N900040100*</b>	<b>Setup</b>	<b>Start</b>	<b>*NS1*</b>
<b>Revision ID:</b>						
<b>Item Name:</b>	Bearpaw Assembly				<b>Stop</b>	<b>*NS2*</b>
<b>Start Date:</b>	9/24/14	<b>Start Qty:</b> 2.00	<b>*2*</b>	<b>Cust Item ID:</b>		
<b>Required Date:</b>	9/30/14	<b>Req'd Qty:</b> 2.00	<b>*2*</b>	<b>Customer:</b>		
<b>Reference:</b>						

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run** **Start** **\*NR1\***  
                  **QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Stop** **\*NR2\***

[illegible]

150	QC8- Inspect parts - second check	0.00	
<b>*150*</b>			
QC	Memo	0.00	<div style="display: flex; justify-content: space-around; align-items: center;"> <span>3</span> <span>Ø</span> </div>
Quality Control			<b>DAS 45</b> <del>9.89</del> 14/08/28

152	Pick Kit	0.00	
<b>*152*</b>			
Packaging	<b>Memo</b>	0.00	3x 14/09/29
Packaging			36 9-89

# Work Order ID 124827

September-24-14 8:44:23 AM

**\*124827\***

Page 3

Item ID: D4353-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearpaw Assembly  
 Start Date: 9/24/14 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 9/30/14 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
153		0.00							
<b>*153*</b>									
Small Fab	Memo	0.00							
Small Fab	PRESS D4353-3 INSERT INTO BEARPAW								
154									
	QC5- Inspect part completeness to step on W/O	0.00							
<b>*154*</b>									
QC	Memo	0.00							
Quality Control									
155									
	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
<b>*155*</b>									
Packaging	Memo	0.00							
Packaging									

3x 14/9/29 36 9-89 DAS  
 (3) 14-9-29 38 9-89 DAS

**Work Order ID 124827****\*124827\***

Page 4

Item ID: D4353-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw Assembly

Start Date: 9/24/14 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 9/30/14 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

MCS 14-09-29

① 14-9-29

# Picklist Print

September-24-14 8:44:23 AM

Page 1

Work Order ID: 124827

**\*124827\***

Parent Item: D4353-041

**\*D4353-041\***

Parent Item Name: Bearpaw Assembly

Start Date: 9/24/14

Required Date: 9/30/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-04-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB10

Purchased

No

sf

771.4000

13

**\*MUHMWB10\***

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**\*\***

09/24/14

Location

Loc Qty

Loc Code

MAT014

371.4

m128267

47

m128668

297.3

m129293

27.1

TPI

400

m130421

400

Each

2.0000

2

**\*\***

14/09/14

DAS  
36  
9-89

D4353-3

Manufactured

No

**\*D4353-3\***

Bearpaw Insert

Location

Loc Qty

Loc Code

ST101

1

121182

1

ST104

1

70727

1

B124862

3x

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 124827
<b>Description:</b> Bearpaw		<b>Part Number:</b> D4353-1
<b>Inspection Dwg:</b> D4353 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

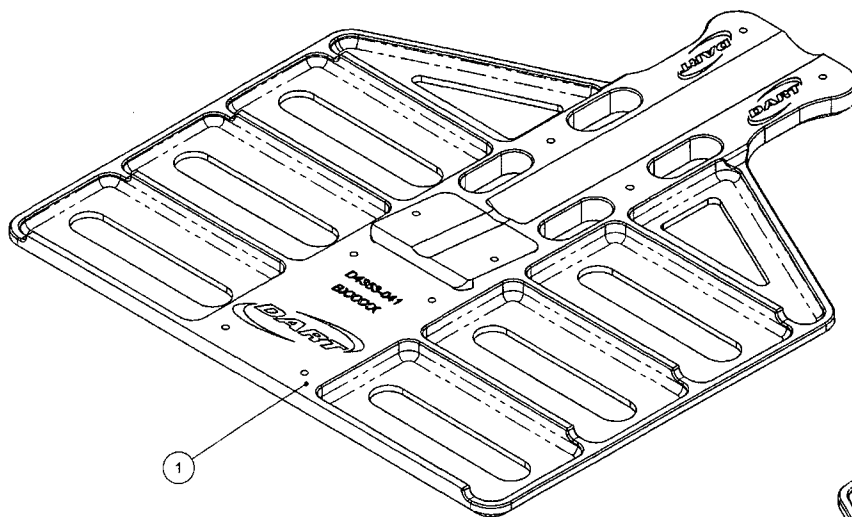
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	.379	✓		Vern	M-L-06
7.375	+/-0.010	7.375	✓		"	
12.50	+/-0.030	12.500	✓		M-type	M-L-08
1.38	+/-0.030	1.377	✓		Vern	M-L-06
3.813	+/-0.010	3.813	✓		"	
24.00	+/-0.030	24.000	✓		M-type	M-L-08
10.09	+/-0.030	10.090	✓		"	
1.00	+/-0.030	1.000	✓		Vern	M-L-06
6.150	+/-0.010	6.150	✓		M-type	M-L-08
3.038	+/-0.010	3.038	✓		"	
6.563	+/-0.010	6.563	✓		"	
9.250	+/-0.010	9.250	✓		"	
27.00	+/-0.030	27.000	✓		"	
1.25	+/-0.030	1.250	✓		Vern	M-L-06
0.30 x 45°	+/-0.030	.295x45	✓		"	
1.38	+/-0.030	1.370	✓		"	
0.63	+/-0.030	.630	✓		"	
0.95	+/-0.030	.955	✓		"	
R0.25	+/-0.030	R.250	✓		R-L	
0.70	+/-0.030	.700	✓		Vern	M-L-06
0.07 x 45°	+/-0.030	.070x45	✓		"	
Ø0.650	+/-0.010	Ø.653	✓		"	
Ø0.261	+0.006/-0.001	Ø.261	✓		"	
0.400	+/-0.010	.401	✓		"	
4.750	+0.012/-0.000	4.750	✓		"	
4.000	+0.012/-0.000	4.006	✓		"	
5.75	+/-0.030	5.750	✓		"	
0.63	+/-0.030	.630	✓		"	
0.57	+/-0.030	.580	✓		"	
0.25	+/-0.030	.247	✓		"	
0.45	+/-0.030	.448	✓		"	
0.06 x 45°	+/-0.030	.065x45	✓		"	
R0.25	+/-0.030	R.250	✓		R-L	

<b>Measured by:</b> <i>mk</i>	<b>Audited by:</b> 45	<b>Preliminary Approval:</b>
<b>Date:</b> 14/09/27	<b>Date:</b> 14/09/28	<b>Date:</b>

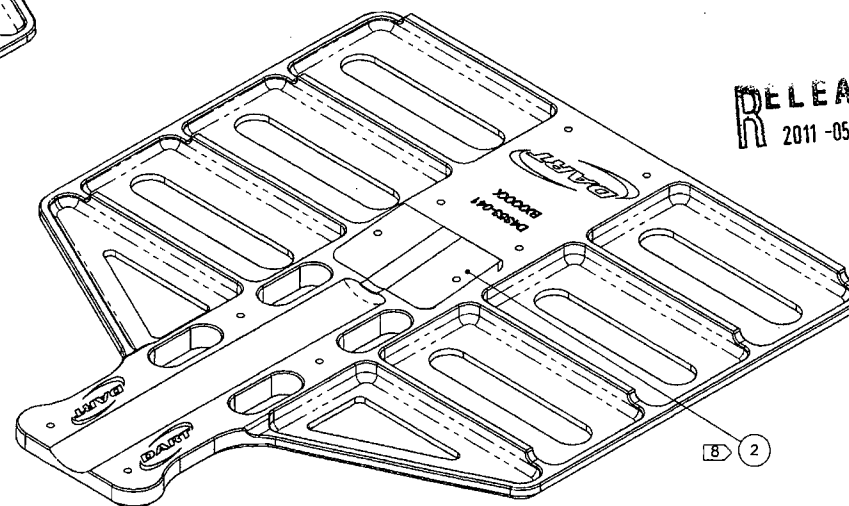
Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	<i>[Signature]</i>

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D4353-041	429 BEARPAW ASSEMBLY
1	1	D4353-1	429 BEARPAW
2	1	D4353-3	429 BEARPAW INSERT



**D4353-041 429 BEARPAW ASSEMBLY**



*al024827*

**RELEASED**  
2011-05-24  
AND

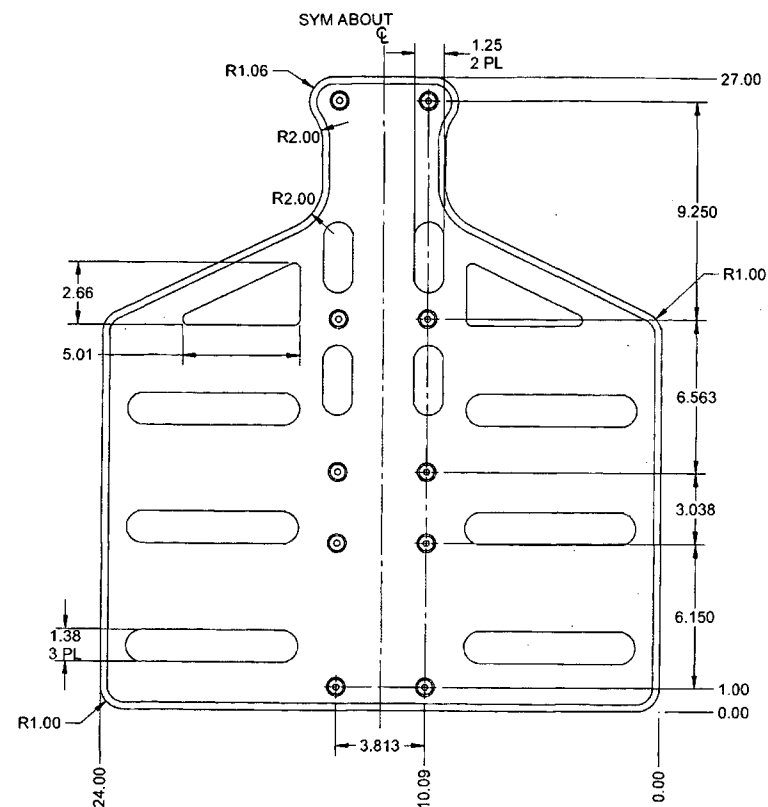
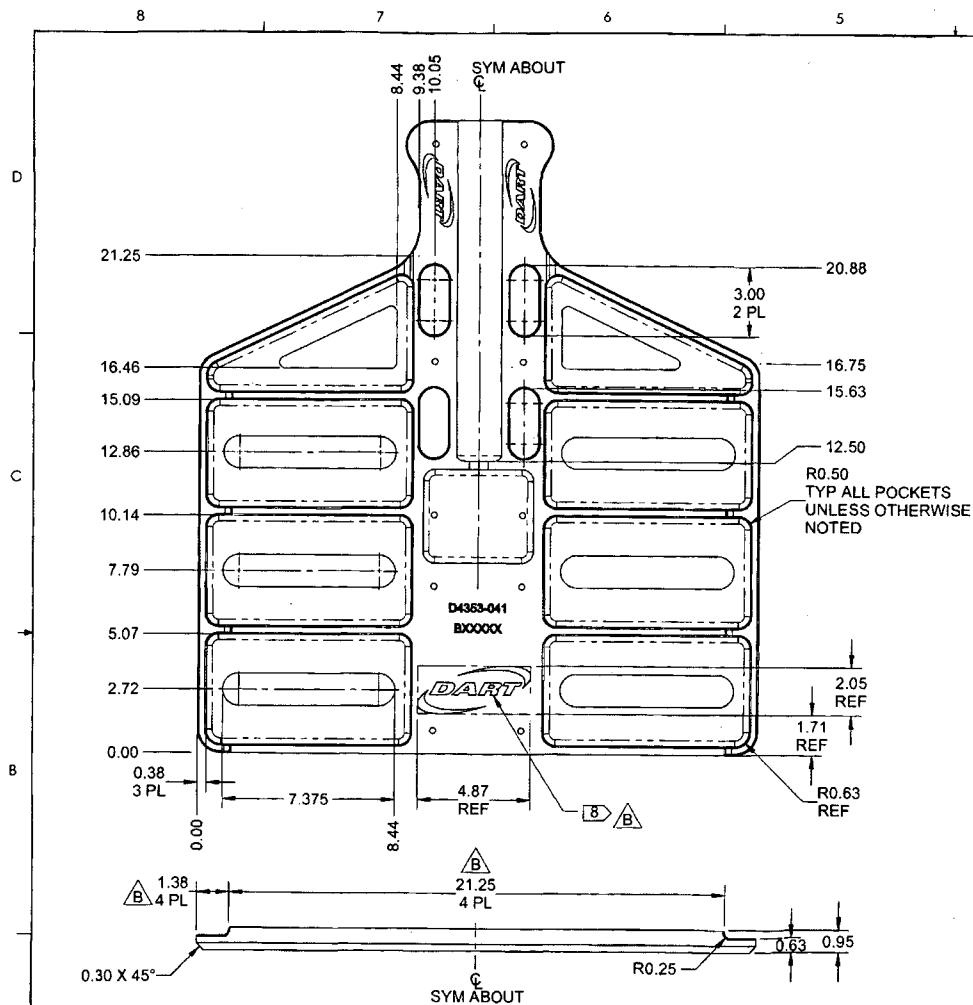
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.45 lbs
- 8) PRESS FIT



B	SHT 1 WEIGHT CORRECTED WAS 8.24 lbs. SHTS 1-3 DART LOGOS UPDATED. SHT 2, ZONE B8, AFT POCKET REDUCED, RIB INCREASED IN HEIGHT. SHT 3 SECTS. B,C & D RIB INCREASED IN HEIGHT.	AJS	11.04.26
A	NEW ISSUE	AJS	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D4353-1 429 BEARPAW

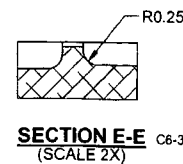
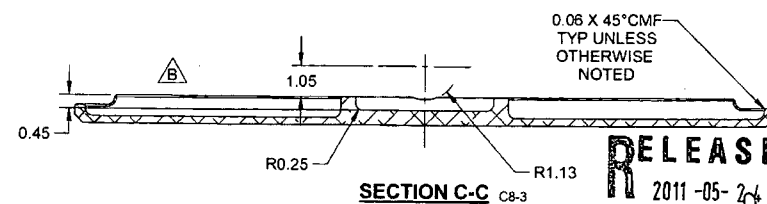
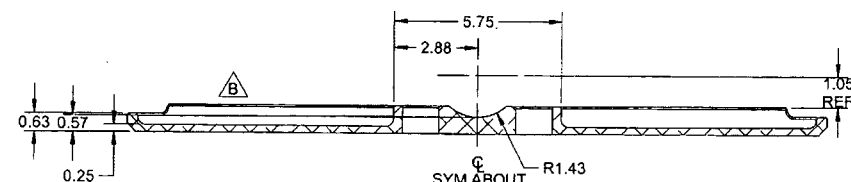
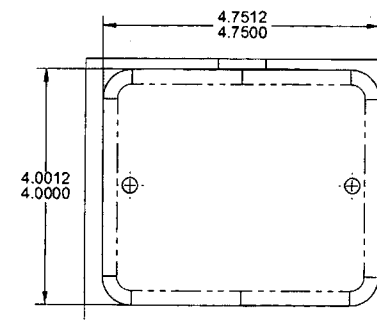
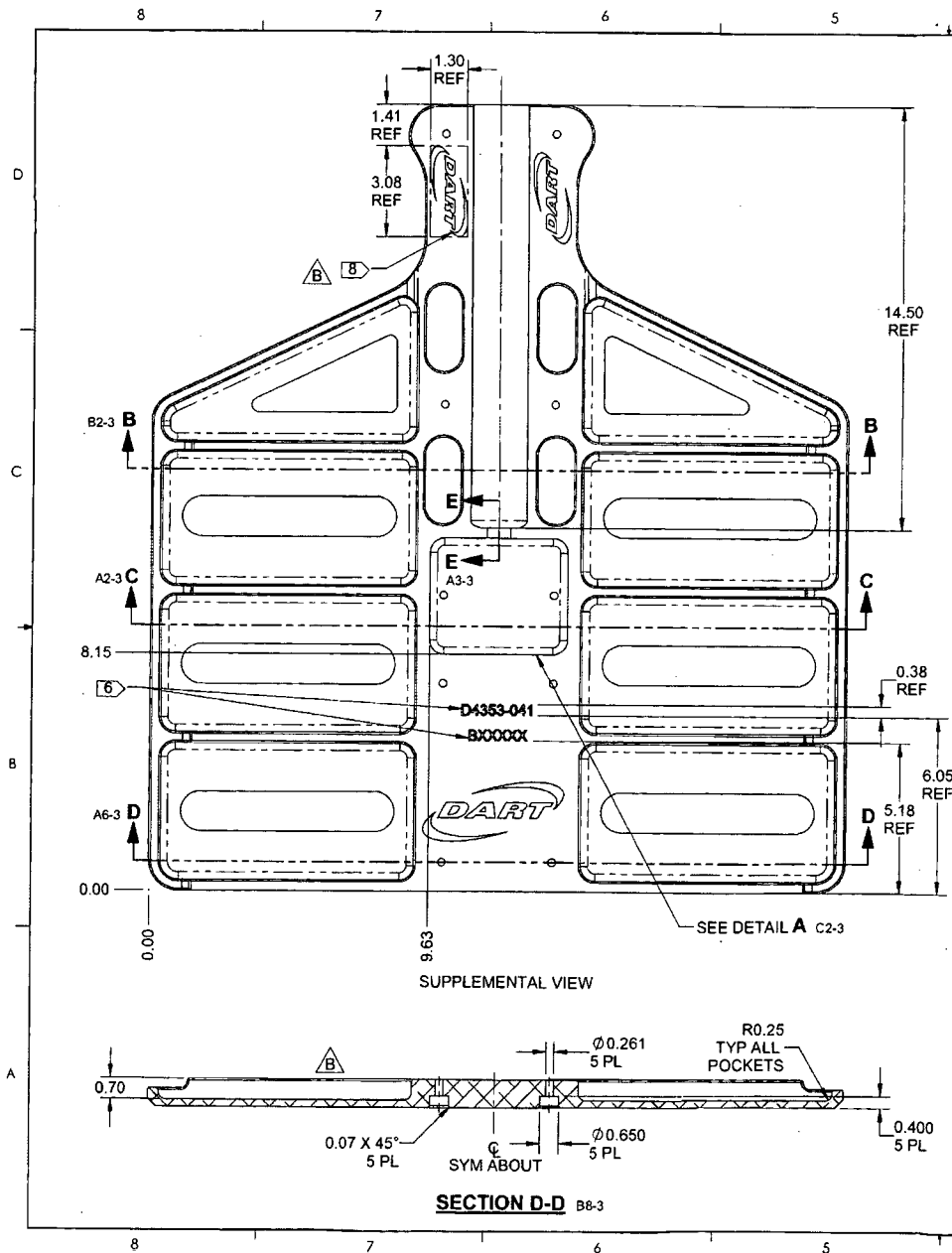
RELEASED  
2011-05-04

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH DART ASSEMBLY P/N "D4353-041" AND B/N "BXXXXX" 0.005 - 0.010 DP AS SHOWN
- 7) WEIGHT: 7.07 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP.

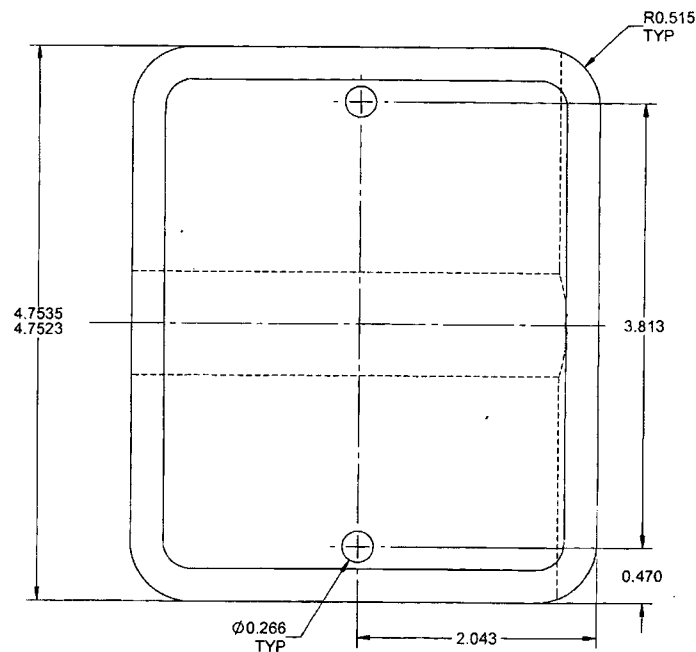
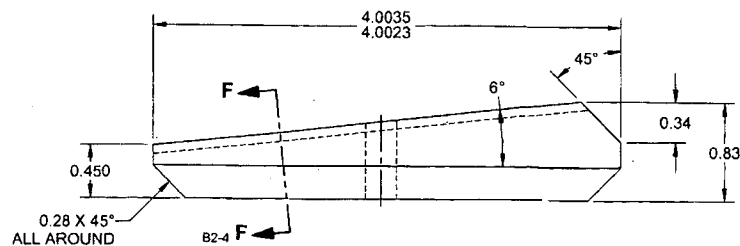
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4353	SHEET 2 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE 429 BEARPAW ASSEMBLY	SCALE NTS
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DATE	11.04.26		



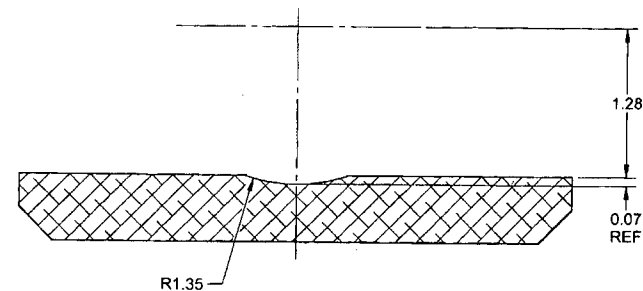
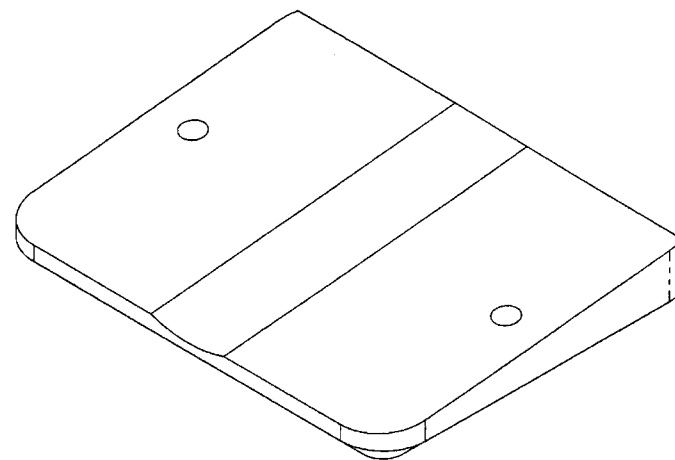


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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4353	SHEET 3 OF 4
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DE APPR.	MP	429 BEARPAW ASSEMBLY	NTS
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RELEASED  
2011-05-24  
JW



**D4353-3 429 BEARPAW INSERT**



**SECTION F-F C7-4**

**RELEASED**  
2011-05-24

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
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